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DART AEROSPACE LTD	Work Order:	21176
Description: Bearpaw Kit (48" x 19") 205/430	Part Number:	K10015
Dwg: D2521 Rev. H	Qty:	5 Kits
Ref: K10015 Rev. A; DSK086-6 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required	HA	04.07.05	5																																								
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 (Bag Bluefiles separately)	HA DH	04.07.07	5																																								
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMBW10) Batch: <u>M15075</u>	SL	04/08/05	5																																								
4	MV	Inspect material for defects or damage prior to machining	SL	04/08/05	5																																								
5	MV	Machine as per Folio FA222 and Dwg D2521 Identify as D2521	SL	04/08/09	5																																								
6	QC2	Inspect parts as they come off the CNC machine	SL	04/08/09	5																																								
7	MV	Deburr	SL	04/08/09	5																																								
8	MV	Form as per Dwg D2521 using bending Jig DT8328	SL	04/08/09	5																																								
9	QC8 & 5	Second inspection	SL	04.08.10	5																																								
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>8</td><td>D2182B055</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>16</td><td>D2274</td><td>Radius Block</td><td>B20927</td></tr><tr><td>2</td><td>D2521</td><td>Bearpaw</td><td>B21176</td></tr><tr><td>16</td><td>D2529</td><td>Washer</td><td>B20964A</td></tr><tr><td>8</td><td>D2947</td><td>Clamp</td><td>B19991</td></tr><tr><td>16</td><td>AN4-15A</td><td>Bolt m13437/m12903/m7809/14544</td><td></td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>m15020</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m14764</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	8	D2182B055	Rubber Cushion	B20434	16	D2274	Radius Block	B20927	2	D2521	Bearpaw	B21176	16	D2529	Washer	B20964A	8	D2947	Clamp	B19991	16	AN4-15A	Bolt m13437/m12903/m7809/14544		16	AN960JD416	Washer	m15020	16	MS21042L4	Nut (or -4)	m14764	1	Paperwork package from Step 2			CL	04/08/10	5
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1	Paperwork package from Step 2																																												
11	QC4	Inspect Kit for 100% Completeness on the W/O	CL	04/08/10	5																																								
12	PK	Identify and pack for shipping as per PPP K10015 Rev.c	CL	04/08/10	5																																								
13	AC	Cost / part <u>396.00</u>	SAC	04-08-13	5																																								
14	DC	Close W/O <u>384.78</u> Inspect Level 21	SL	04.08.16	5																																								

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	
C	04.02.17	Tolerance added to Step 3	KJ/JLM	

RELEASED
04.02.20

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	21176
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.000	+/-0.030	1.000	✓			
B	5.600	+/-0.030	5.591	✓			
C	11.500	+/-0.030	11.492	✓			
D	10.250	+/-0.010	10.250	✓			
E	13.250	+/-0.010	13.250	✓			
F	8.500	+/-0.010	8.500	✓			
G	22.125	+/-0.030	22.124	✓			
H	8.75	+/-0.010	8.745	✓			
I	44.500	+/-0.030	44.500	✓			
J	6.688	+/-0.030	6.688	✓			
K	5.625	+/-0.030	5.619	✓			
L	7.000	+/-0.030	7.000	✓			
M	5.000	+/-0.010	5.000	✓			
N	4.000	+/-0.030	3.988	✓			
O	6.625	+/-0.030	6.623	✓			
P	19.000	+/-0.030	19.003	✓			
Q	0.31 x 45°	+/-0.030	0.314	✓			
R	0.19 x 45°	+/-0.030	0.195	✓			
S	0.50 x 45°	+/-0.030	0.500	✓			
T	0.38 x 45°	+/-0.030	0.373	✓			
U	0.063 x 45°	+0.030/-0.010	0.063	✓			
V	Ø0.260	+0.005/-0.000	0.260	✓			
W	Ø0.93	+/-0.030	0.928	✓			
X	0.30	+0.030/-0.010	0.300	✓			
Y	0.375	+/-0.010	0.373	✓			
Z	0.750	+/-0.030	0.745	✓			
AA	0.250	+/-0.010	0.245	✓			
AB	4.000	+/-0.030	3.994	✓			
AC	6.625	+/-0.030	6.623	✓			
AD	0.950	+0.030/-0.010	0.947	✓			
AE	0.375	+/-0.010	0.373	✓			
AF	3.399	+/-0.030	3.397	✓			
AG	6.625	+/-0.030	6.623	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 04/09/05	Date: 04-06-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	<i>[Signature]</i>

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 01, 2004
02:00 pm

Work Order No : 0021176
Project Name : K10015
Project For : WK429
Work Order Type : Main
Main WO Number :
House Part Number : *K10015
Description : Bearpaw Kit
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 07-01-04
Est Finish Date : 07-16-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00